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D3078-042
Job Sheet 182138



Part No: D3078-042

Job Qty: 4 ea

Part Name: Step Assembly, Hi Short RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/17/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A 15.10.21 NEW ISSUE DD VERF:JLM IPP REV:B 15.11.12 REV.C3 DD VERF:JLM
IPP REV:C 16.03.15 DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		9/7/18	0.00	0.00	Start Up Large Fab-4		MACE 18-10-31
110	Large Fab	4 pcs		9/7/18	0.00	4.80	Large Fab 8		MACE 18-10-31
120	QC	4 pcs		9/7/18	0.00	0.00	QC6		DAS Cpc
130	Large Fab	4 pcs		9/7/18	0.00	4.80	Large Fab 2		43 Cpc
140	QC	4 pcs		9/7/18	0.00	0.00	QC9		9-89 Cpc
150	QC	4 pcs		9/7/18	0.00	0.00	QC5		Cpc
160	HandFinish	4 pcs		9/7/18	0.00	0.83	HandFinish1		D.R 18/11/02
170	QC	4 pcs		9/7/18	0.00	0.00	QC7-2		Cpc
200	Large Fab	4 pcs		9/7/18	0.00	4.80	Large Fab 2		Cpc
210	QC	4 pcs		9/7/18	0.00	0.00	QC10		Cpc
220	QC	4 pcs		9/7/18	0.00	0.00	QC5		Cpc
230	HandFinish	4 pcs		9/7/18	0.00	0.83	HandFinish6		D.R 18/11/19
240	Powdercoat	4 pcs		9/7/18	0.00	0.76	Powdercoat1		BEB 18-11-20
250	HandFinish	4 pcs		9/7/18	0.00	0.83	HandFinish3	XJRH	DAS 2018-11-20
260	QC	4 pcs		9/7/18	0.00	0.00	QC3		DAS 38
290	Packaging	4 pcs		9/7/18	0.00	0.00	Packaging3-1		46 NOV 22 2018
300	QC21-SA	4 Ea		9/7/18	0.00	0.00	QC21		9-89

Part Op 110 - 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680
Descriptions: for rivets. 3-Deburr

130 - 1-Bevel end for welding FWD ONLY 2-Weld Support, weld Fwd End Plate as per QSI 004 & Dwg D3078
A/RAluminum Rod M134785 3-Grind End Plate flush

200 - 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024
4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod 5-Grind End Plate flush

M138951 240 - START TIME: 11:25 OVEN TEMPERATURE: 320 FINISH TIME: 11:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 Ea (.5 ea)	90-Start up Operation	3104007
D3067-1	End Plate	4 Ea (1 ea)	130-Large Fab	3104284
D3219-3	Plate	8 Ea (2 ea)	130-Large Fab	3107461
D3065-041	Step Leg Assembly	4 Ea (1 ea)	200-Large Fab	3126166
D3066-1	Spacer	8 Ea (2 ea)	200-Large Fab	3101804

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

D3067-1
MS20600-AD4W4

End Plate
Rivet

4 Ea (1 ea)
64 Ea (16 ea)

200-Large Fab
200-Large Fab

5104284
5117999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	2	0	0
130-Large Fab	D3067-1	4	153	0
	D3219-3	8	29	0
200-Large Fab	D3065-041	4	48	0
	D3066-1	8	186	0
	D3067-1	4	153	0
	MS20600-AD4W4	64	2,084	0

Part Specifications

Specifications could not be found.

Plex 8/17/18 2:19 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____	DISPOSITION Rework _____ Scrap _____ Use-as-is _____ Suspected Unapproved _____
Part No. _____	
NCR No. _____	

Date : _____	Step #: _____
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Description Work Order Deviation

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

☐	Pressure/Forced
☐	Bending
☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Wave/Twist in Tube
☐	Marks/Chatter

FAULT CATEGORY

☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Contamination	☐	Out of Sequence	☐	Part Moved
☐	Countersink	☐	Off-set	☐	Drawing
☐	Cut Too Short	☐	Mislabeled	☐	Finish
☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence

OTHER :

Revision: _____
Inspector: _____
Exp Date: _____
Instructions: Various STC's

Part: D3078 - 042
Job No: 182138
Serial No/Batch: S122920

Date: 10/30/18



Container No: S122920

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